



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4776-3
Job Sheet 192191



Part No: D4776-3

Job Qty: 24 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4776 REV.E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	3/29/19	3/29/19	0.00	0.00	Start Up Machining-3		mmc 19/04/19
100	Bandsaw	24 pcs	3/29/19	3/29/19	0.00	0.43	Bandsaw1		"
110	CNC Vertical Machining	24 pcs	3/29/19	3/29/19	0.26	20.87	HAAS1-5		"
120	QC	24 pcs	3/29/19	3/29/19	0.00	0.00	QC2 Machining-3		"
130	QC	24 pcs	3/29/19	3/29/19	0.00	0.00	QC8 Machining-3		mmc 19/04/19
140	HandFinish	24 pcs	3/29/19	3/29/19	0.00	0.64	HandFinish1		D.B. 19/04/19
150	QC	24 pcs	3/29/19	3/29/19	0.00	0.00	QC7-4		19-04-2
160	Powdercoat	24 pcs	3/29/19	3/29/19	0.00	0.29	Powdercoat1		19-04-2
170	QC	24 pcs	3/29/19	3/29/19	0.00	0.00	QC3		APR 02 2019
180	Packaging	24 pcs	3/29/19	3/29/19	0.00	0.00	Packaging3-2	ST115 90	APR 03 2019
190	QC21-SA	24 Ea	3/29/19	3/29/19	0.00	0.00	QC21		APR 03 2019

Part Op 100 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB168 DWG REV: E FOLIO REV: A 2- deburr and break all sharp edges160 - START TIME: 11:05 OVEN TEMPERATURE: 300 FINISH TIME: 11:35

M138997

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	9.2640 ft (.386 ea)	90-Start up Operation	① 5124463 ② 5052919

X13
X

Job Allocations

Operation	Required	Inventory	Allocated
DART AEROSPACE	9	12	0

Container No: S167891



Part: D4776-3

Job No: 192191

Serial No/Batch: S167891

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/29/19

Plex 3/19/19 9:22 AM Dart.lajeunesse.marie

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.430inches ± 0.030	4.460 4.400	4.440"	Cal
2	Skidtube Clevis	2.300inches ± 0.030	2.330 2.270	2.305"	at 1.9 gauge
3	Skidtube Clevis	1.778inches ± 0.010	1.788 1.768	1.775"	at 1.9 gauge
4	Skidtube Clevis	0.880inches ± 0.030	0.910 0.850	.879	Cal
5	Skidtube Clevis	0.510inches + 0.010 - 0.000	0.520 0.510	.514	
6	Skidtube Clevis	1.063inches ± 0.010	1.073 1.053	1.0645	
7	Skidtube Clevis	1.380inches ± 0.030	1.410 1.350	1.375	
8	Skidtube Clevis	0.190inches ± 0.030	0.220 0.160	.190	
9	Skidtube Clevis	0.100inches ± 0.010	0.110 0.090	.096	
10	Skidtube Clevis	0.484inches + 0.006 - 0.001	0.490 0.483	Diameter .485	ok / .490 No 90
11	Skidtube Clevis	0.500inches ± 0.030	0.530 0.470	.500	
12	Skidtube Clevis	0.640inches ± 0.030	0.670 0.610	.638	
13	Skidtube Clevis	3.150inches ± 0.010	3.160 3.140	3.153	
14	Skidtube Clevis	1.080inches ± 0.010	1.090 1.070	1.081	
15	Skidtube Clevis	0.688inches ± 0.010	0.698 0.678	.688	
16	Skidtube Clevis	0.397inches + 0.006 - 0.001	0.403 0.396	Diameter .397	
17	Skidtube Clevis	1.863inches ± 0.010	1.873 1.853	1.865	
18	Skidtube Clevis	0.190inches ± 0.030	0.220 0.160	Radius .190	
19	Skidtube Clevis	0.130inches ± 0.030	0.160 0.100	Radius .130	
20	Skidtube Clevis	0.440inches ± 0.030	0.470 0.410	Radius .440	
21	Skidtube Clevis	0.125inches ± 0.010	0.135 0.115	.122	
24	Skidtube Clevis	0.250inches ± 0.030	0.280 0.220	Radius .250	
25	Skidtube Clevis	1.050inches ± 0.030	1.080 1.020	Product 1.045	
26	Skidtube Clevis	1.430 ± 0.030		1.419	
27	Skidtube Clevis	1.130inches ± 0.030	1.160 1.100	Product 1.115	
28	Skidtube Clevis	0.060 ± 0.030		Product .060	
29	Skidtube Clevis	0.810inches ± 0.030	0.840 0.780	Product .810	
30	Skidtube Clevis	0.060 ± 0.030		Product .06	
31	Skidtube Clevis	0.183inches ± 0.010	0.193 0.173	Product .1825	

Plex 3/19/19 9:22 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					